

Date: Thursday, 8/23/2007 11:52:40 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 34238		
Estimate Number	: 11139		
P.O. Number	:	Part Number	: D32051
This Issue	: 8/23/2007 S.O. No. :	Drawing Number	: D3205 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 30830	Material	:
Written By	:	Due Date	: 9/3/2007 Qty: 5 Um: Each
Checked & Approved By	: <u>0822.0823</u>		
Comment	: Est A 04.06.09 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M7075T73B2500X0325	7075-T73 Bar 2.5 x 3.25"
-----	--------------------	--------------------------



Comment: Qty.: 0.3828 f(s)/Unit Total: 1.5313 f(s)

7075-T73 Bar 2.5 x 3.25"

Material: 7075-T73 (QQ-A-200/11 or QQ-A-250/12) or 2024-T3 (QQ-A-200/3 or QQ-A-250/4)

(M7075T73B2.500x03.25)

Identify for D3205-1

Batch: M102694 ml 08/02/02 (5)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks: 3.250" x 2.500" x 4.250" long Bar (+0.030/-0.000) ml 08/02/02 (5)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Machine D3205-1 as per Folio FA346 and Dwg D3205

Identify as D3205-1

Deburr and Tumble ml 08/02/04 (5)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE ml 08/02/04 (5)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK ml 08/02/04 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3205-1 PAR #: N/A Fault Category: Prod/Machine ^{PAF} NCR: Yes No DQA: 12 Date: 08/02/08
 QA: N/C Closed: 12 Date: 08 02 08

NCR: <u>34238</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.02.04	3.0	1 part 0.600 is 0.589	LE 08.02.04	Acceptable	N/A	08.02.04	LE 08.02.04	08.02.04
08/02/04	3	1 piece scrap the dim. 1.750 is 1.690 R.C. operator error. try to remachining the piece and put at the wrong place	08/02/04	scrap ^{destroy} and replace Batch: M102694 Qty 1	me 08/02/04	08/02/04	08/02/04	08-02-04
08/02/04	3	1 piece scrap the 100° chamfer at wrong place of 100°	08/02/04	scrap destroy and replace Batch: M102694 Qty 1	me 08/02/04	08/02/04	08/02/04	08/02/04

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:52:40 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 34238

Part Number: D32051

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(5X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-h 08/02/06

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Cover the thread hole for D3205-1 before powder coat.

FL 08/02/07 (5)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(5X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-h 08/02/07

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 200*

AS 08/02/07 (5)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

D 08/02/08

Job Completion



in 2008/2/07 (5)

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector





Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

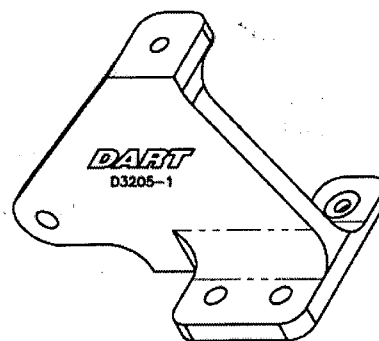
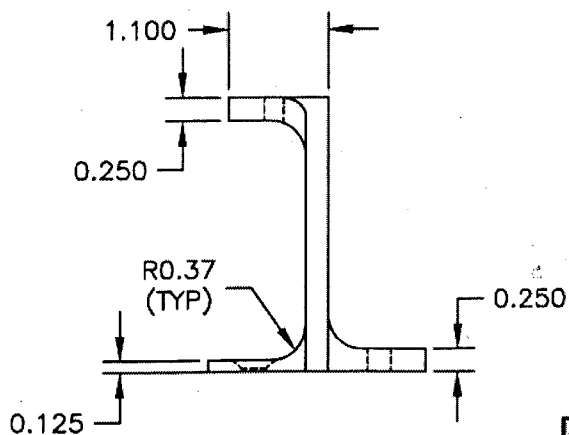
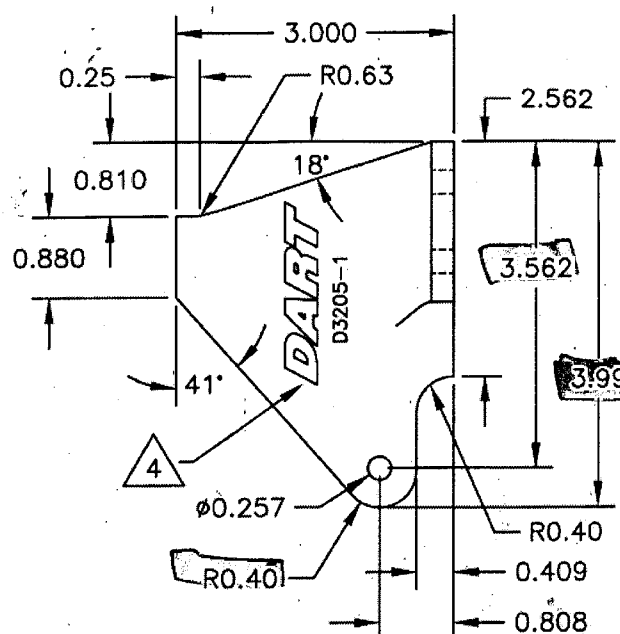
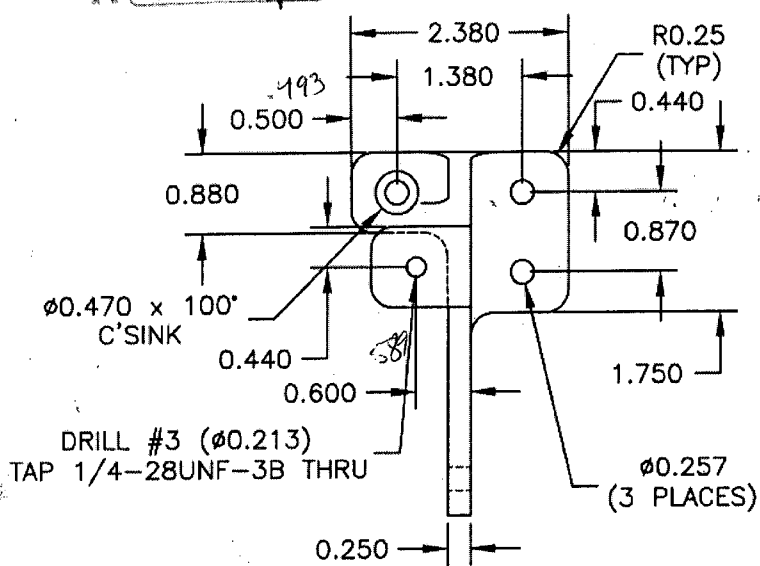
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D3205 REV. A SHEET 1 OF 2	
DATE 04.01.27		TITLE BRACKET		SCALE 1:2	
A	04.01.27		NEW ISSUE		

RELEASED
04.04.05 #



D3205-1 PEDAL BRACKET

NOTES:

- NOTES:**
- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015.
 - 2) MATERIAL: 7075-T73 (QQ-A-200/11 OR QQ-A-250/12)
OR 2024-T3 (QQ-A-200/3 OR QQ-A-250/4)
 - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART
 - 4) ENGRAVE DART P/N & LOGO AS SHOWN
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 6) ALL DIMENSIONS ARE INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
SI 005, 4.334238

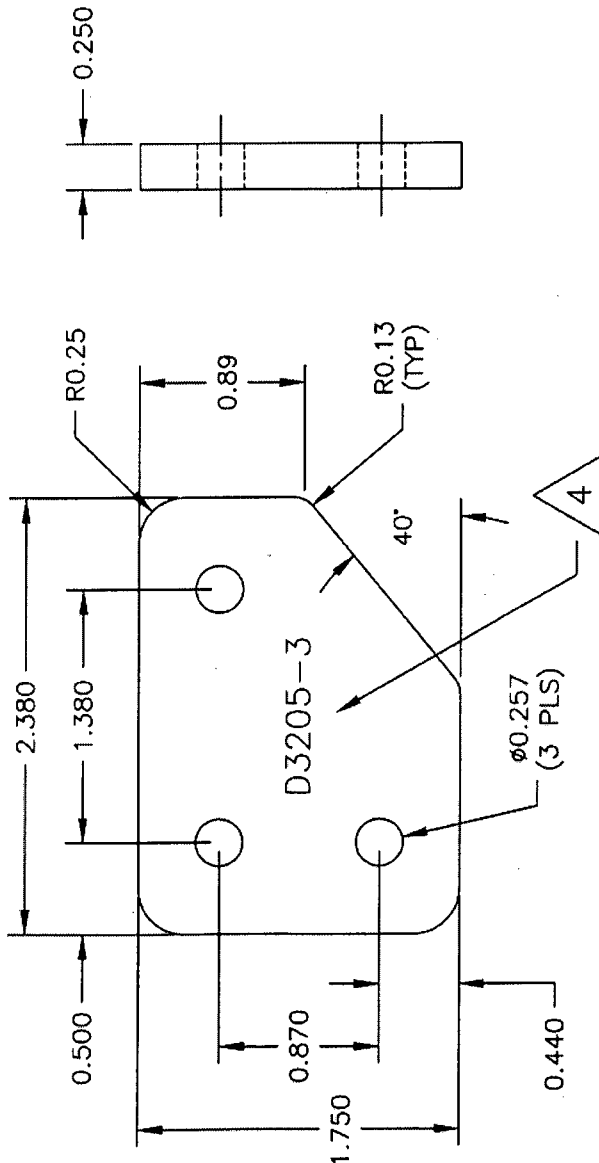
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3205	REV. A SHEET 2 OF 2
DATE 04.01.27		TITLE BRACKET	SCALE 1:1

RELEASED
04.04.05



D3205-3 BACK PLATE

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) ALUMINUM BAR (M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 34238

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order: 34238
Description: Pedal Bracket		Part Number: D3205-1
Inspection Dwg: D3205	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.006	—			
0.250	+/-0.010	.258	—			
R0.37	+/-0.030	R.375	—			
0.125	+/-0.010	.128	—			
0.250	+/-0.010	.250	—			
2.380	+/-0.010	2.383	—			
1.380	+/-0.005	1.378	—			
0.500	+/-0.005	.508	—			
0.880	+/-0.010	.880	—			
Ø0.470 x 100°	+0.005/-0.000	Ø0.475 x 100°	—			
0.440	+/-0.005	.435	—			
0.600	+/-0.005	.595	—			
1/4-28UNF-313	N/A	—	—			
0.250	+/-0.010	.247	—			
Ø0.257	+0.005/-0.000	Ø0.259	—			
1.750	+/-0.010	1.750	—			
0.870	+/-0.005	.870	—			
0.440	+/-0.005	.440	—			
R0.25	+/-0.030	R.250	—			
3.000	±.010	3.001	—			
2.562	±.010	2.563	—			
3.562	±.010	3.564	—			
.880	±.010	.880	—			
3.99	±.030	3.963	—			
.808	±.010	.810	—			

Measured by: <i>Amf</i>	Audited by: <i>Amf</i>	Prototype Approval: N/A
Date: 08/02/03	Date: 08.02.04	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	<i>Amf</i>

